AMENDMENTS TO THE CLAIMS:

Please amend the claims as follows:

1. (Currently Amended) A stamping process in which a metal sheet T is stamped between a bottom die 10 and a punching die 4 clamped by front (AV) and rear (AR) blank holders, characterized in that the blank holder AR 20 is widened toward a ~~the~~ rear ~~relative to the dimensions of the prior art~~ and, at the end adjacent to the punching die 4 which is ~~(that is,~~ the front (AV) end of the rear (AR) blank holder~~)~~, has a convex form~~, that is, a form~~ which permits progressive deformation of the metal sheet in depth and over a greater blank holder length, and is not a ~~in place of the~~ right angle blank holder ~~of blank holders of the prior art~~.

2. (Currently Amended) A stamping process in which a metal sheet T is stamped between a bottom die 10 and a punching die 4 clamped by front (AV) and rear (AR) blank holders, wherein the rear blank holder (AR) 20 is widened toward a ~~the~~ rear and is geometrically adapted to the level of the area 14 adjacent to the punching die 4 in order to reproduce a portion of the ~~at least one part of the~~ form created by the punching die 4 in its AV part, wherein said portion can optionally be ~~or to reproduce~~ precisely one-half, or more than one-half, up to the entirety of the form created by the punching die 4.

3. (Currently Amended) The stamping process as specified in claim 1, wherein the front blank holder (AV) 30 is also widened toward a front ~~(toward the front)~~.

4. (Previously Presented) The stamping process as specified in claim 1, wherein the geometric adaptation of the blank holder AR represents one-half the form created by the punching die 4 in its AV part.

5. (Currently Amended) The stamping process as specified in claim 1 adapted for manufacture of multiple-seat benches that have ~~, in particular ones with~~ two to six or eight seats or more, requiring several consecutive seat forms or imprints 11, 12 separated by interval i, wherein use is made of a tool the AR blank holder 100 of which reproduces (in its part B) at least one portion that can optionally be ~~part, preferably~~ precisely one-half (A) of the seat form 11, 12 created by the punching die 120 in its AV part, or optionally ~~creates~~ more than one-half, up to the totality, of the form created by the punching die.

6. (Currently Amended) The stamping process as specified in claim 5 adapted for manufacture of multiple-seat benches that have ~~, in particular with~~ six to eight or more seats, requiring a plurality of consecutive seat forms or imprints 11, 12 separated by an interval i, wherein the blank holder AR 100 and the punching die 120 are in an area the geometry of which is adapted for reproduction of the desired form of the interval i defined as mandatorily present between two consecutive seat forms.

7. (Currently Amended) The stamping process as specified in claim 5 adapted for manufacture of multiple-seat benches that have ~~, in particular ones with~~ two to six or eight or more seats, requiring a plurality of consecutive seat forms or imprints 11, 12 separated by an interval i, wherein the blank holder has been widened toward the front.

8. (Currently Amended) The stamping process as specified in claim 5, adapted for manufacture of multiple-seat benches that have ~~, in particular ones with~~ two to six or eight or more seats, requiring a plurality of consecutive seat forms or imprints

11, 12 separated by an interval i, wherein the profile 8 of the blank holder AV 110 remains horizontal.

9. (Currently Amended) The stamping process as specified in claim 5, wherein the blank holder 110 has ~~may have~~ a slightly convex surface or profile favoring transition in deformation from the metal sheet to the punching die.

10. (Currently Amended) The stamping process as specified in claim 1, wherein the metal sheet T is positioned so as to produce a first stamping form or initial stamping and ~~"initial stamping,"~~ then the metal sheet which has undergone this first stamping or initial stamping is then displaced toward the rear and the initial stamping is brought to rest in area 130 AV of the blank holder AV of the blank holder AR 100, after which a ~~the~~ second stamping is repeatedly carried out ~~and so forth~~ until 2, 3, 4, 5, 6, 7, or 8 imprints or more have been produced.

11. (Currently Amended) The stamping process as specified in claim 1, wherein the blank holder AR 100 reproduces in a ~~its~~ part B one-half of the seat imprint, which is identical to half-form A of part AV of the punching die 120, an ~~the~~ arrow indicating the direction of step-by-step movement of the metal sheet to permit production of consecutive imprints.

12. (Previously Presented) The stamping process as specified in claim 1, wherein the tool comprises, between the blank holder AR 100 and the punching die 120, a shoulder 150 which reproduces the interval i which must be present between two consecutive seat imprints.

13. (Currently Amended) The stamping process as specified in claim 1, wherein a pressure of ~~the order of~~ 150 to 300 or 350 ~~to~~ is applied for a metal sheet of 15/10 mm or of 12/10 mm or of 10/10, 8/10, or 6/10 mm.

14. (Currently Amended) The stamping process as specified in claim 1, wherein this shoulder 150 forming interval i is reduced to values of ~~the order of~~ 1 to 3 or 5 cm for 15/10 mm metal sheets, or ~~even one~~ measuring 10/10 or 8/10 or 6/10 mm, or ~~even preferably~~ to a value i = 0, without marking and without folds or curls.

15. (Currently Amended) The stamping process as specified in claim 1, wherein at least one part of base part B of blank holder AR 100 is replaced with other support means or by ~~, such as~~ friction rollers~~, etc~~.

16. (Currently Amended) The stamping process as specified in claim 1, wherein the stamping process comprises a metal sheet performing step~~, preferably performing~~ by means of a folding machine.

17. (Currently Amended) The stamping process as specified in claim 16, wherein the metal sheet is preformed along line a, b, c, rounded part d, e, f, with all sections being straight except curved section d, or the preform is made up of sections a, h (straight), d, e, f, or the preform is made up of sections a, h (straight), d, g (straight).

18. (Currently Amended) The stamping process as specified in claim 1, wherein the metal sheet T is positioned without concern for vertical alignment with the punching die 4 and the punching die 10, and ~~it being possible for~~ the metal sheet is ~~to~~

~~be~~ offset ~~, for example,~~ by distance m relative to the vertical alignment, and wherein the press is then lowered slowly and the metal sheet is allowed to center itself on the tool.

19. (Currently Amended) A tool for application of the stamping process as specified in claim 1, characterized in that such tool comprises a bottom die 10 and a punching die 4 clamped by front (AV) and rear (AR) blank holders, and in that the blank holder AR 20 is widened toward the rear ~~in comparison to the dimensions of the prior art~~ and has on an ~~the~~ end adjacent to the punching die 4 that is ~~(that is,~~ the front end of the rear ~~extremity)~~ extremity, a convex shape that is ~~, that is,~~ a shape which permits progressive deformation of the metal sheet in depth, and over a greater blank holder length in comparison to a ~~to the~~ right angle blank holder ~~of blank holders of the prior art~~.

20. (Currently Amended) The tool as specified in claim 19, wherein the rear blank holder (AR) 20 is widened toward the rear and is geometrically adapted at the level of area 14 adjacent to the punching die for reproduction of at least a portion ~~one part~~ of the form created by punching die 4 in its AV part, said portion optionally being ~~or~~ one-half or more than one-half, and up to the entirety of the form created by the punching die.

21. (Currently Amended) The tool as specified in claim 19, wherein the blank holder (AV) 30 is also widened toward a front ~~(toward the front)~~.

22. (Currently Amended) The tool as specified in claim 19, wherein geometric adaptation of the blank holder AR reproduces in a ~~its~~ part B one-half A of the shape created by the punching die in its part AV.

23. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches requiring a plurality of consecutive seat forms or imprints 11, 12, of ~~in particular~~ two to six or eight seats or more, separated by an interval i, wherein blank holder AR 100 reproduces at least one portion, said portion optionally being ~~part, preferably~~ one-half the seat form produced by the punching die 120 in its AV part, or ~~reproduces~~ more than one-half, up to the entirety, of the form created by the punching die.

24. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches, requiring a plurality of consecutive seat forms or imprints 11, 12 separated by an interval i, of ~~in particular~~ two to six or eight seats or more, wherein there is between the blank holder AR and the punching die 120 an area 150 the geometry of which is adapted for reproduction of the desired shape of the interval i ~~defined as~~ mandatorily present between two consecutive seat forms, i optionally equaling zero.

25. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches of ~~, in particular~~ two to six or eight or more consecutive seat forms or imprints 11, 12 separated by an interval i, wherein the blank holder AV 110 has been widened toward the front.

26. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches of ~~, in particular~~ two to six or eight or more consecutive seat forms or imprints 11, 12 separated by an interval i, wherein the tool comprises between the blank holder AV 100 and the punching die 120 a shoulder 150

which reproduces the interval i which must be present between two consecutive seat imprints.

27. (Currently Amended) The tool as specified in claim 19, wherein, in order that the stamping pitch may be modified as desired, the tool is designed in two separate parts by a transverse cut ~~(that is, one~~ perpendicular to the direction of advance of the metal sheet~~)~~ at the level of the center of the punching die (4, 120), this forming the base tool at minimum pitch, which parts ~~may be~~ separated from each other by a ~~the desired~~ pitch modification value E, and wherein the tool comprises one or more sets of four dismountable pieces called bottom die 460, punching die 480, and blank holder 490 and 420 shims adapted for insertion into space E in an appropriate set.

28. (Currently Amended) The tool as specified in claim 27, wherein such tool is adapted for manufacture of multiple-seat benches of ~~, in particular for~~ two to six or eight seats or more, requiring a plurality of consecutive seat forms or imprints 11, 12 separated by an interval i.

29. (Currently Amended) The tool as specified in claim 26, wherein such shims of bottom die 460, punching die 48, and blank holder 49 and 20 are ~~may be~~ fastened by a ~~any~~ mechanical means or by bolting ~~such as bolting, etc~~.

30. (Currently Amended) ~~Stamping presses~~ A stamping press equipped with a tool as specified in claim 19.

31. (Currently Amended) Stamped articles and products that ~~, in particular ones such as~~ include successive repetitive imprints, wherein ~~in particular whenever~~ the imprints are close together, or ~~even~~ adjacent (i = 0), and ~~in particular benches~~ with a plurality of seats of ~~, in particular six or more, in particular~~ two to six or eight seats or more, ~~characterized in that such stamped articles and products have~~ ~~been~~ manufactured by a process as specified in claim 1.

32. (Currently Amended) Stamped articles as specified in claim 31, wherein the ~~such~~ articles are made with metal sheets of a thickness of ~~various customary thicknesses, in particular~~ 15/10, 12/10, or 10/10 mm, of a ~~various common or~~ stainless steel ~~steels~~, optionally provided with a temporary, provisional, or definitive coating, or under a finishing layer, or again made of plates of plastics or composites ~~of any type~~.

33. (Currently Amended) A set of a ~~Sets of~~ bottom die 460, punching die 480, and blank holder 490 and 420 shims as specified in claim 27.